

Date: Thursday, 05/02/2009 3:42:27 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ARM
 Job Number : 45543
 Estimate Number : 11969
 P.O. Number :
 This Issue : 05/02/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D2065
 First Issue : / / Type : SMALL / MED FAB Drawing Number : D2065 REVC
 Previous Run : 41524 Project Number : N/A
 Material :
 Due Date : 20/02/2009 Qty: 10 Um: Each
 Written By :
 Checked & Approved By : JUP 09.02.04
 Comment : Est: E 02.04.15 Added Dwg Rev.B1 NG
 Est Rev:F 08-07-24 revC as per dwg (ecn 08-504) DD verified by:EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304TR0500W049

304 RD Tube .500 x .049W



Comment: Qty.: 1.7063 f(s)/Unit Total : 17.0625 f(s)
 304 RD Tube .500 x .049W
 Seamless Tube
 batch: M108823

SR 09/02/19 (10)

2.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
 1-Punch 1/2" OD x .049" Wall 304/316 SS as per Dwg D2065 (per D2727) using DT8012.
 Note: 1 end only
 2-Cut to length as per Dwg D2065
 3-Form as per Dwg D2065 and template DT8251
 4-Drill 0.188" Dia holes as per Dwg D2065 using drill jig DT8779 and template DT8251
 5-Deburr

SR 09/02/19 (10)

FF 09/02/23 (10X)

M-1 09/02/23

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/23 (10)

4.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
 Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: 8:00am

OVEN TEMPERATURE: 320°

FINISH TIME: 8:30am

M-1 09-02-24 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/02/2009 3:42:27 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 45543

Part Number: D2065

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



10

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BK 04-02-24

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST220

JS 09/02/25 (x)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/25

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 09/02/25

Dart Aerospace Ltd

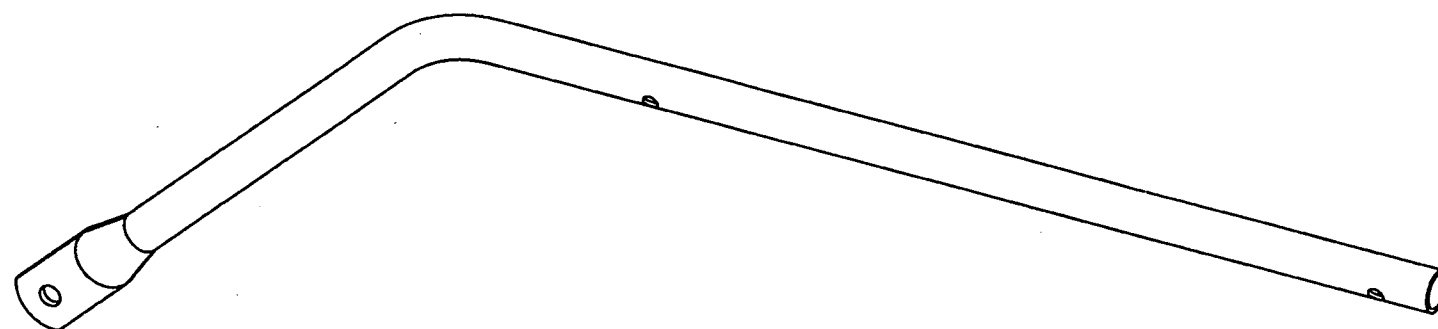
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



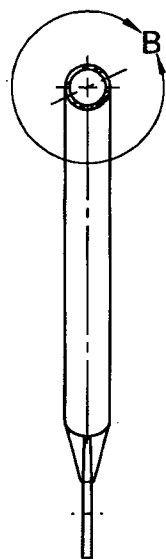
D2065 ARM

RELEASED
08-07-23-117

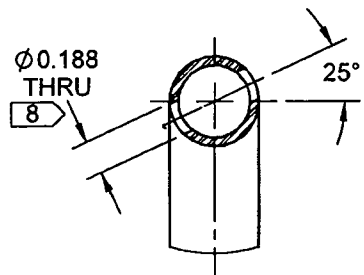
REV.	DESCRIPTION	BY	DATE
C	REDRAWN IN SOLIDWORKS; INCORPORATED REV. B1 (FINISH ADDED VIA HAND CHANGE) (ZN A6-2); ADD D2065F CUT LENGTH DETAIL FOR D2065 (ZN B3-2); ADD R1.50 DIMENSION (ZN D5-2); Ø 0.500 X 0.049 WALL WAS Ø 0.500 X 0.035 WALL (ZN A5-2); REASON: Ø 0.500 X 0.035 WALL TUBING USED ON D2010 IS CRACKING DURING SERVICE	PH	08.06.13
B	RE-DESIGN	BW	96.02.06
A	NEW ISSUE	BW	92.03.12
DESIGN	BW	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2065	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ARM	NTS
DATE	08.06.13	COPYRIGHT © 1992 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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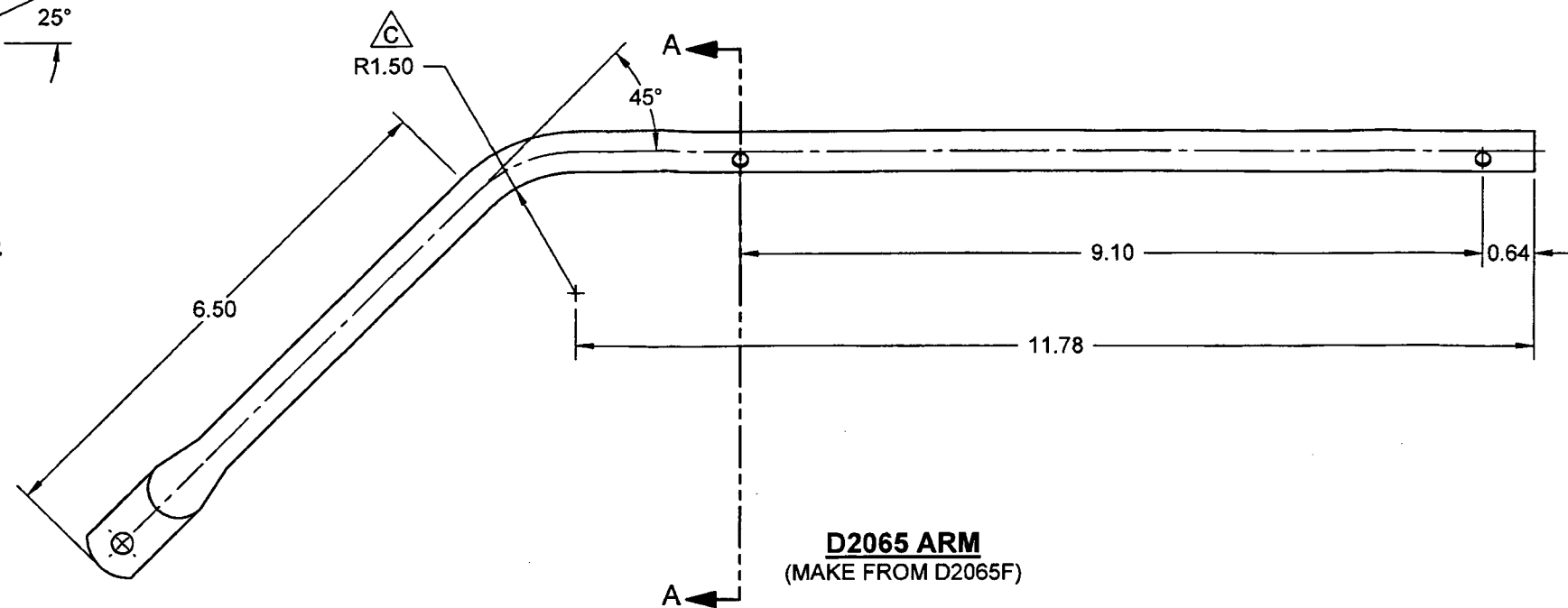
8 7 6 5 4 3 2 1



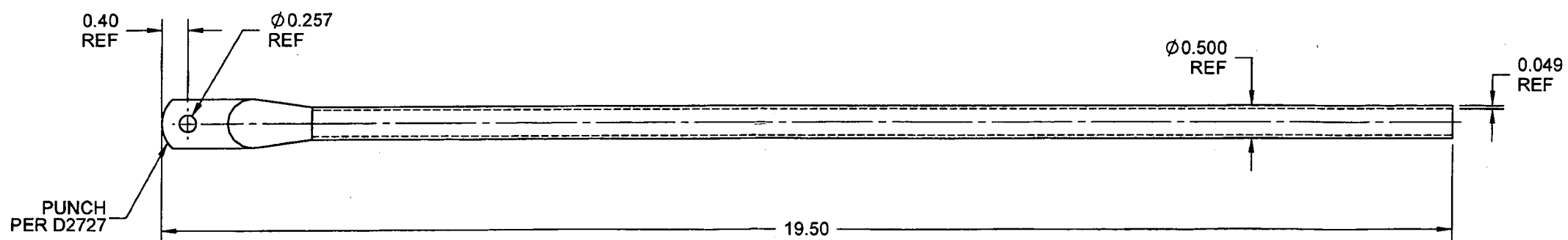
SECTION A-A



DETAIL B
SCALE 3X
2 PL



D2065 ARM
(MAKE FROM D2065F)



D2065F ARM CUT LENGTH DETAIL

- NOTES:
- 1) MATERIAL: D2065F: AISI 304/316 SS SEAMLESS ROUND TUBING, $\phi 0.500 \times 0.049$ WALL (REF DART SPEC M304TR0.500W.049)
 - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.41 lbs
 - 8) DRILL $\phi 0.188$ AFTER BENDING

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	PH	
CHECKED		DRAWING NO. D2065
MFG. APPR.		SHEET 2 OF 2
APPROVED		TITLE ARM
DE APPR.		SCALE NTS
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08.07.23/18

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